Work Order I April-04-14 10:22:14			*11 <i>9</i>	5807*						Page	1
Item ID: D349 Revision ID: Item Name: Plug	92-3		Accept	*N900	040	100)*			VS1*	
Start Date: 4/04/ Required Date: 4/04/ Reference:		1 1 /1 /		Cust Item l Customer:	D:					N.7/**	
Approvals: Pro	ocess Plan: MUS	Date: 14-04-09	Tooling:	D	ate:	- 			art *\	JR1 *	
QC	:	Date:	SPC (Y/N):	D:	ate:			31	_{որ} *խ	JR2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numbe		
Draw Nbr	Revision Nbr		-						····	· · · ·	
D3492	Е		•								
100	Hardinge CNC LATH	E SMALL	0.00				107	Ø		DAS 20 9-89	14-05-14
Hardinge Hardinge CNC Lathe Smal	Memo 1-Turn as Dwg Rev Folio Rev	s per Folio FA632 & Dwg D34 : <u><i>E</i></u> ::_ <u>Aß</u>	0.00 92				<u></u>				_ ·
110	QC2- Inspect parts of	f machine FAI/FAIB	0.00				107			DAS	
110 QC Quality Control	Мето	Ţ	0.00				102	Ø		20 — 9-8 9-	14-05-14
120-	QC8- Inspect parts - s	econd check	0.00				107			DAS 40	i
120 QC Quality Control	Мето		0.00				107				- 4/05/14

DQA:		_ Date:			_								TOACT		
					WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only										
QA Closed:		Date:		_	-				W	ork Order up	date only		`		
Work Order	r:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
					Rework		Skid-tube Crosstube Water Je						Engineering		
Part No	0.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality		
					Use-as-is		Thern	moforming	Finishing	Rec/Stor	e/Packaging		Other		
NCR No	0				Suspected Unapproved			Large Fab	Composite		Supplier				
Root		1		Desci	ription of work order update		nitial	Actio	on	Sign &			· · · · · · · · · · · · · · · · · · ·		
Cause	Date	Step	Qty		or non-conformance		ief Eng			Date	Verification	,	QC Inspector		
Design		<u> </u>						2 22 2 1 1							
Doc/Data		1													
Equip/Tooling															
Handling/Pre															
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Operator												ĺ			
Offset/Setup	V			•								ļ			
Process		'		: "					-						
Supplier															
Training								}							
Transport								1	•						
Unapproved															
* 64f						FAI	ULT CAT	TEGORY							
Landing	g Gear				General										
L	Bending			<u> </u>	Bend		Folio/P	Program		Outside Dim	ensions		Pressure/Forced		
	Centre N	lot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up		
L	Cracks				Broken/Damage/Defect		Hardwa	are	:	Part Incorred	:i [Ц	Temperature/Cure		
		ink/Ripple	/Wave		Burrs	_	1	ion Incomplete/Unq	· -	Part Lost/Mi	ssing	\Box	Weld		
· L	Cuffs				Contamination	-	4	tions Incomplete/Un	nclear	Part Moved	L		Wrong Stock Pulled		
· <u> </u>	Crushing				Countersink	-	_	gned/off center		Positioned W					
_	Heat Tre				Cut Too Short	—	Mislabe			Power Loss/S	Surge		Other		
<u> </u>	 -	on Strip in	Tube		Drawing	-	Misread								
	Marks/C				Drill Holes	L.	Off-set								
		Sequence			Finish	L	1	Calibration							
	Wave/T	wist in Tub	е		Fit/Function		Out of S	Sequence							

1//0

(Flat End Only)

START TIME: OVEN TEMPERATU

FINISH TIME:

DAS

0.00

27

150

150 QC

Quality Control

Memo

QC3- Inspect Part Finish

DQA:			Date:				_	01150		DATE					DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UP	DATE	W	ork Order u	odate only	Г	AER OSPĀCE
Marile Ord						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Ord	er:					Rework	1		Skid-tube Crosstube Water Jet						1
Part I	N۵					Scrap			Machining Machining	Crosstube Small Fab	⊢	- Dro	water jet d. Eng. Coor.	\vdash	Engineering Quality
i aiti	1 0.					Use-as-is	1		noforming	Finishing	lacksquare	-	u. Eng. Coor. re/Packaging	-	Other
NCR I	Vo.					Suspected Unapproved			Large Fab	Composite		1 100/310	Supplier		
			1	·					, , ,			T		•	
Root				۱	Desci	ription of work order update	1	Initial	Actio			Sign &			
Cause	ı	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descrip	otion		Date	Verificatio	n	QC Inspector
Design						!									
Doc/Data	\vdash														
Equip/Tooling	<u> </u>														
Handling/Pre Material	\vdash												:		
Operator	\vdash								ļ						
Offset/Setup	\vdash														
Process	-														
Supplier															·
Training				}											
Transport															
Unapproved	_		ļ												
		· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·				FA	ULT CA	TEGORY			<u>. </u>	 		
Landi	ng (Gear				General		,							
		Bending				Bend		Folio/F	Program			Outside Dim	ensions	Г	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorre	i		Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unq	qualified		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Un	nclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center			Positioned V	Vrong		_
i		Heat Trea	at			Cut Too Short	Mislabeled Power Loss/Surge O				Other				
		Inspectio	n Strip in	Tube		Drawing .		Misread	d						
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Out of Sequence						

Work Ord April-04-14 10:		.5807		*115	5807 *							Page 3
Item ID: Revision ID: Item Name:	D3492-3		A	Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	4/04/14 4/04/14	Start Qty: 100.00 Req'd Qty: 100.00	*100* *100*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: _ SPC (Y/N):		ite:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Stoo	k Location: (FQ-60)	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
160 Packaging		Мето		0.00				107	((<u>HL</u>	MUSIZ
											1	10

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

170

170 QC

Quality Control

14/5/22 A) MUS 1405-22

DQA:			Date:											DART		
QA Closed:			Date:			WORK ORDER NON	-CONFORMANCE / UPDATE Work Order update only									
Work Orde	or.				-	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	•			
Part N	۱o.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier					Engineering Quality Other		
		-					ı		carge ras	composite		Supplier				
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance		nitial ief Eng	Actio Descri		Sign & Date	Verification	n	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved																
							FAI	JLT CAT	regory							
Landi		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple, at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Und ions Incomplete/Ur ned/off center eled	·	Over/Under tolerance Set-up Part Incorrect Tempera Part Lost/Missing Weld			Temperature/Cure Weld Wrong Stock Pulled		
		Wave/Tw				Fit/Function		ŧ	Calibration Sequence		_					

Picklist Print

April-04-14 10:22:14 AM

Work Order ID: 115807

115807

Parent Item:

D3492-3

D3492-3

Parent Item Name: Plug

Start Date: 4/04/14

Required Date: 4/04/14

Page 1

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	43.9111	0.06	7			DAS
*M6061T6	SR0 750	*							**	417			20 9-86 14-0

6061-T6 Round Bar .750"

Location	Loc Oty	Loc Code	
MAT012	43.911052		
m126852	19.911052		6,2117'
m128573	24		

DQA:			_ Date:			-								TAΩ
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDAT			.		AEROSPACE
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·		T	.	W	ork Order up	date only		
Work Orde	er:					DISPOSITION			AC	GAINST DE	EPARTMENT,	/PROCESS		
	•					Rework	1		Skid-tube Cro	osstube	7	Water Jet		Engineering
Part N	No.					Scrap			—	nall Fab	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is		1	· —	inishing	-1	e/Packaging	7	Other
NCR N	No.					Suspected Unapproved			· —	nposite	1	Supplier	7	
							•					, <u>-</u>		
Root					Desci	ription of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	1	Date	Verification	<u>1</u>	QC Inspector
Design														
Doc/Data														
Equip/Tooling						•								
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process											ļ			
Supplier														
Training														
Transport														
Unapproved	j													
							FA	ULT CA	TEGORY		· · ·			
Landi						General		1			7	Г	_	
	_	Bending				Bend	_	1	Program	ļ 	Outside Dim		_	ressure/Forced
:	\vdash	Centre No	ot Concen	ntric		BOM/Route		Grain			Over/Under		_	et-up
	-	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		–	Part Incorred	⊢	_	emperature/Cure
	_	Crimp/Kii	nk/Ripple,	/Wave	_	Burrs		1	ion Incomplete/Unqualifi		Part Lost/Mi	ssing		Veld
	-	Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear	r [Part Moved	L		Vrong Stock Pulled
	-	Crushing			-	Countersink		-1	gned/off center	<u> </u>	Positioned W			
/	_	Heat Trea			<u> </u>	Cut Too Short		Mislabe			Power Loss/:	Surge	0	ther
	Ī	Inspectio	•	Tube	<u> </u>	Drawing	L	Misread						
		Marks/Ch				Drill Holes		Off-set						
,		Turning S			<u> </u>	Finish		4	Calibration					·
		Wave/Tw	ist in Tub	e		Fit/Function	l	Out of S	Sequence			•		

DART AEROSPACE LTD	Work Order:	115807
Description: Plug	Part Number:	D3492-3
Inspection Dwg: D3492 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	.747	V		5602	Mic
Ø0.582	+0.000/-0.002	.5815	V		1 (
0.045	+0.000/-0.002	.0445	/		SL08	Vein
0.060	+/-0.005	.060	V			
0.060	+/-0.005	.060	/			·
0.500	+/-0.010	.500				
0.090	+0.000/-0.002	.0895	/		V	
					,	
						·
	DAS		DAS			

 Measured by:
 9-89
 Audited by:
 9-89
 Preliminary Approval:

 Date:
 14-05-14
 Date:
 14/05/14
 Date:

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue P/O D3492-043	KJ/JLM	
В		Ø0.750 was Ø0.625	KJ/JLM	
С	08.09.04	Tolerance revised for Ø0.750	KJ/DD	
D	11.06.21	Dwg Rev updated	KJ	
E	12.10.26	Tolerance revised for Ø0.582	KJ]	<u> </u>
F	14.01.21	Dwg Rev updated	KJ. S	<u> </u>

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

7	DESCRIPTION	PART NUMBER	QTY -055	QTY -053	QTY -051	QTY -049	QTY -047	QTY -045	QTY -043	QTY -041
7	PLUG ASSEMBLY	D3492-041								X
٦	PLUG ASSEMBLY	D3492-043							X	
1	PLUG ASSEMBLY	D3492-045						Х		
7	PLUG ASSEMBLY	D3492-047					X			
7	PLUG ASSEMBLY	D3492-049				X				
7	PLUG ASSEMBLY	D3492-051			Х					
Π.	PLUG ASSEMBLY	D3492-053		Х						
/E	PLUG ASSEMBLY	D3492-055	X							
4	PLUG	D3492-1								1
\dashv	PLUG	D3492-3	 						1	
\dashv	PLUG	D3492-5						1		
-	PLUG	D3492-7	 				1		-	
┪	PLUG	D3492-9	i			1				
ヿ	PLUG	D3492-11			1	-				
٦	PLUG	D3492-13		1						
/E	PLUG	D3492-15	1							
-	O-RING	NAS1611-005		-				1		
┪	O-RING	NAS1611-007					1			
1	O-RING	NAS1611-010								1
7	O-RING	NAS1611-012		1						•
7	O-RING	NAS1611-013							1	
٦	O-RING	NAS1611-015	1		1					
7	O-RING	NAS1611-016				1				

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

115807 MLS

S

D

13.08.08

D	WAS 0.0	PORATED DEO 055. (SEE CAR1	AJS	11.05.24			
С	ADD -04	19/-051/-053, CH	PH	07.10.05			
В	ADD -04	7; UPDATE DIN	PH	06.05.11			
Α	NEW IS	SUE	PH	06.01.04			
REV.	DESCR	IPTION	BY	DATE			
DESIGN PH			DART AEROSPACE LTD				
DRAWN		AP	HAWKESBURY, ONTARIO, CANADA				
CHECKED		455	DRAWING NO.		REV. E		
MFG. APPR.		<i>P</i>	D3492		SHEET 1 OF 2		
APPROVED		149	TITLE	···	SCALE		
DE APPR		-#	PLUG		итѕ		
DATE 13.08.08			COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND COMPOSITION, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS, NOT TO BE USED FOR MAY PURPOSE OR CORPED OR COMMUNICATED TO MAY OTHER PERSON WITHOUT WRITTEN PERMISSION FOR MOMENT APPROPACE TD.				

ADD -055 PLUG ASSY & -15 PLUG

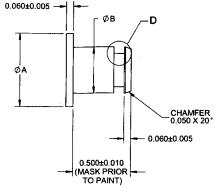
D

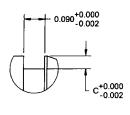
POWDER COAT THESE FACES ONLY PER NOTE 2

D

С

В





DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	С	MATERIAL SPEC	1
D3492-1	0.625	0.394	0.050	M6061T6R0.625	٦
D3492-3	0.750	0.582	0.045	M6061T6R0.750	٦
D3492-5	0.375	0.188	0.045	M6061T6R0.375	٦
D3492-7	0.500	0.270	0.045	M6061T6R0.500	٦
D3492-9	0.938	0.750	0.045	M6061T6R1.000	٦
D3492-11	0.850	0.664	0.045	M6061T6R0.875	٦
D3492-13	0.750	0.510	0.045	M6061T6R0.750	٦
D3492-15	0.850	0.640	0.050	M6061T6R0.875	٦

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-220/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, O	NTARIO, CANADA	
CHECKED	155	DRAWING NO.	REV. E	
MFG. APPR.	177	D3492	SHEET 2 OF 2	
APPROVED	NO	TITLE	SCALE	
DE APPR.	-#-	PLUG	4:1	
DATE 13.0	80.80	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS REWATE AND COMPREHENIA, AND IS REPREZE ON THE EXPRESS CONCITION THAT IT IS NOT TO BE USED FOR MYT PURPOSE ON COMPRED OR COMMUNICATED TO MY OTHER PERSON WITHOUT MENTTON PERMISSION FROM DART ARROSPING, U.D.,		

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